

# Work Order ID 65416

Monday, January 17, 2011 9:08:29 AM



Page 1

Item ID:	D3835-1KIV	Accept		Setup	Start	
Revision ID:						
Item Name:	Hat Bin-Ivory				Stop	
Start Date:	1/18/2011	Start Qty:	1.00			
Required Date:	1/31/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>11-01-17</u>	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr

100		0.00							
	HandThermo	Memo	0.00			x3			<u>DL</u>
Hand Finishing Thermoforming	1) Machine set up								<u>11/09/18</u>
	1) Cut sheet to required blank size								

105		0.00							
	Dry Material	Memo	0.00			x3			<u>DL</u>
HandThermo	Dry Sheet as per QSI022 KYDEX								<u>11/01/19</u>
Hand Finishing Thermoforming	Temp: <u>150° F</u>								
	Time IN: <u>4:00 pm</u> <u>11/01/18</u>								
	Time OUT: <u>2:00 am</u> <u>11/01/19</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65416**

Monday, January 17, 2011 9:08:30 AM

Page 2

Item ID: D3835-1K1V

Accept

Revision ID:

Item Name: Hat Bin-Ivory

Start Date: 1/18/2011 Start Qty: 1.00

Required Date: 1/31/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #  
Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3835-1 and folio FTA037

Dwg. Rev. CFolio Rev. B

x2

x1

Dh

→ PTO.

120

0.00



QC

Memo

0.00

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Dh

130

0.00



QC

Memo

0.00

Quality Control

QC8- Inspect parts - second check

x2

B

11/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 03835-1K1V PAR #: \_\_\_\_\_ Fault Category: Thermforming NCR: Yes No DQA: [Signature] Date: 11-01-19  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 11-01-20

NCR: <u>65416</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/01/19	110	MATERIAL TOO HOT. BLISTERED, 1st part pulled.  R.C. Process	[Signature]	SCRAP 1 UNIT. ADJUST HEAT <sup>on folio</sup> AND REPLACE UNIT.	[Signature] 11/01/19	S 11/01/20	[Signature]	[Signature] 11-01-19
11/01/19	110.	1 UNIT USED FOR HAI	[Signature]	MARK UNIT AS RED ONLY. DO NOT Replace	[Signature] 11/01/19	S 11/01/20	[Signature]	[Signature] 11-01-19

NOTE: Date & initial all entries

**Work Order ID 65416**

Monday, January 17, 2011 9:08:30 AM

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Item ID: D3835-1KIV

Accept

Revision ID:

Item Name: Hat Bin-Ivory

Start Date: 1/18/2011 Start Qty: 1.00

Required Date: 1/31/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1) Trim to Finished Dimension

x2

Dh  
11/01/19

150

0.00



QC

Memo

0.00

Quality Control

x2

Dh  
11/01/19

160

0.00



QC

Memo

0.00

Quality Control

Sulaleo

(x1)

(x2)

QC2- Inspect parts off machine FAI/FAIB

QC5- Inspect part completeness to step on W/O

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65416**

Monday, January 17, 2011 9:08:30 AM

Page 4

Item ID: D3835-1K1V

Accept

Revision ID:

Item Name: Hat Bin-Ivory

Start Date: 1/18/2011 Start Qty: 1.00

Required Date: 1/31/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PO# 65417

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/20 ②

11/01/20  
ME  
11-01-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, January 17, 2011 9:08:26 AM

Page 1

Work Order ID: 65416



Parent Item: D3835-1KIV



Parent Item Name: Hat Bin-Ivory

Start Date: 1/18/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC  
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.125-P3- 62015		Purchased	No			100	sf	917.0100	11.42	11.42			



6185 KYDEX .125"



Location

Loc Qty

Loc Code

therm

917.01

917.01

110426

34.40 sq ft.

11/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 65416
Description: Hat Bin		Part Number: D3835-1KIV/KGY
Inspection Dwg: D3835	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Dh

Date: 11/01/19

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.65	+0.05/-0.00	0.67"	✓			
0.80	+0.05/-0.00	0.83"	✓			
1.00	+0.05/-0.00	1.03"	✓			
1.20	+0.05/-0.00	1.22"	✓			
0.050	Min	0.094"	✓			
0.030	Min	0.041"	✓			

Measured by: Dh

Date: 11/01/19

Audited by: B

Date: 11/01/19

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ <u>[Signature]</u>	<u>[Signature]</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

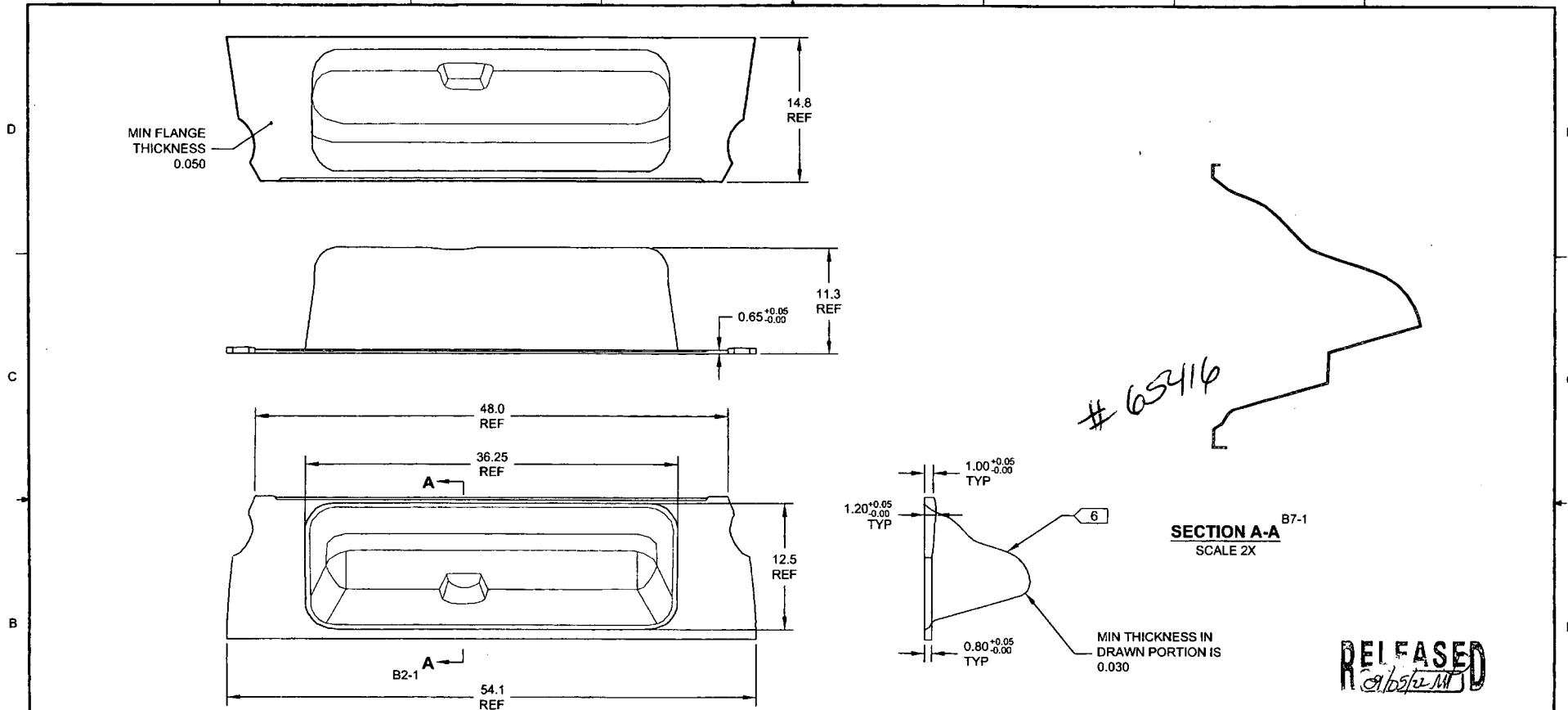
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



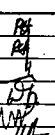
**D3835-1 HAT BIN**  
(BELL 407)

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9449 PER DART QSI 022. TRIM PER MOLD



PART NUMBER	DESCRIPTION
D3835-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
D3835-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3835-1KIV AND ADD STEEL GRAY P/N D3835-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3835	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN (BELL 407)	NT
DATE		09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries